

44

DART AEROSPACE LTD	Work Order:	21583
Description: Bearpaw Installation	Part Number:	D044-662-011
Dwg: D3075 Rev. A2	Qty:	20 Kits
Ref: IIN-D044-662 Rev. B; DSK086-12 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																												
1	DC	Issue Traveler Note: (1) D044-662-011 Kit consists of Qty (2) D3075-1 Dwg not required	JH	04.09.23	20																																												
2	DC	Photocopy bluefile and create labels per PPP D044-662-011 CHG002	JH	04.10.01	20																																												
3	GA	Cut 2 blanks per (1) D044-662-011 Kit Cut blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12 Material: Black UHMW 1" (MUHMWB10) Batch: <u>115926</u>	JH	04/10/26	20																																												
4	MV	Inspect material for defects or damage prior to machining	JH	04/10/26	20																																												
5	MV	Machine as per Folio FA185 and Dwg D3075 Identify as D3075-1	JH	04/10/26	20																																												
6	QC2	Inspect parts as they come off the CNC machine	JH	04/10/26	20																																												
7	MV	Deburr	JH	04/10/26	20																																												
8	QC8 & 5	Second inspection	ED	04/10/27	20																																												
9	KP	Pick: Packing Kit (Note: D3075-1 is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4</td><td>D2182B045</td><td>Rubber Cushion</td><td>B21185</td></tr><tr><td>8</td><td>D2274</td><td>Radius Block</td><td>B21585 / B21188</td></tr><tr><td>8</td><td>D2529</td><td>Washer</td><td>B20964B</td></tr><tr><td>4</td><td>D2882</td><td>Clamp</td><td>B20702A / B20162</td></tr><tr><td>2</td><td>D3075-1</td><td>Bearpaw</td><td>B21583</td></tr><tr><td>4</td><td>AN4-14A</td><td>Bolt</td><td>M14600</td></tr><tr><td>4</td><td>AN4-15A</td><td>Bolt</td><td>M15321</td></tr><tr><td>8</td><td>AN960JD416</td><td>Washer</td><td>M15321</td></tr><tr><td>8</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4	D2182B045	Rubber Cushion	B21185	8	D2274	Radius Block	B21585 / B21188	8	D2529	Washer	B20964B	4	D2882	Clamp	B20702A / B20162	2	D3075-1	Bearpaw	B21583	4	AN4-14A	Bolt	M14600	4	AN4-15A	Bolt	M15321	8	AN960JD416	Washer	M15321	8	MS21042L4	Nut (or -4)	M15020	1	Paperwork package from Step 2			JL	04-10-28	20
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1	Paperwork package from Step 2																																																
10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	04/10/28	20																																												
11	PK	Identify and pack for shipping as per PPP D044-662-011 Rev: B	JL	04-10-28	20																																												
12	AC	Cost / part <u>94.82</u>	JH	04-10-28	20																																												
13	DC	Close W/O <u>95.81</u> Inspect Level 21	JH	04.11.01	20																																												

Rev	Date	Change	Revised By	Approved
A	02.01.15	New Issue	NG/EC	
B	03.06.02	Reformat; Incorporated D3075-1	KJ/RF	
C	04.02.19	Added tolerance and ref to DSK086-12 to Step 3	KJ/JLM	#

BY 04-10-29

RELEASED
04.02.20

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

DART AEROSPACE LTD		Work Order:	21583
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075	Rev: A2	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.060x45°	✓		Vern	
B	0.63	+/-0.030	0.639	✓		Vern	
C	0.250	+/-0.010	0.257	—		Micro	
D	0.950	+0.030/-0.010	0.965	—		Vern	
E	5.50	+/-0.030	5.503	—		Vern	
F	0.25 x 45°	+/-0.030	0.25x45°	✓		Vern	
G	0.900	+/-0.010	0.908	—		Vern	
H	0.375	+/-0.010	0.375	✓		Vern	
I	1.30	+/-0.030	1.290	✓		Vern	
J	5.70	+/-0.030	5.70	✓		Vern	
K	0.37	+/-0.030	0.385	✓		Vern	
L	3.600	+/-0.010	3.598	—		Vern	
M	0.260	+0.005/-0.000	0.260	—		Vern	
N	0.93	+/-0.030	0.927	✓		Vern	
O	0.30	+0.030/-0.000	0.305	✓		Vern	
P	1.08	+/-0.030	1.08	✓		Vern	
Q	5.870	+/-0.010	5.871	✓		Vern	
R	10.14	+/-0.030	10.14	✓		M-Tape	

Measured by: <i>ML</i>	Audited by: <i>EP</i>	Prototype Approval:	N/A
Date: 04/10/26	Date: 04/10/26	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	<i>[Signature]</i>

RELEASED
04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 23, 2004
10:35 am

Work Order No : 0021583
Project Name : D044-662-011
Project For : WK444
Work Order Type : Main
Main WO Number :
House Part Number : *D044-662-011
Description : R44 Bearpaw Kit
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 09-23-04
Est Finish Date : 10-30-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00